

Date: Thursday, 6/21/2007 2:28:48 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : MOUNTING BRACKET
Job Number : 33047	
Estimate Number : 11796	
P.O. Number :	Part Number : D2523
This Issue : 6/21/2007 S.O. No. :	Drawing Number : D2523 REV A2
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A2
Previous Run : 26940	Material :
Written By :	Due Date : 7/28/2007 Qty: 5 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est. C 01.04.16 Re format, added DT8560 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X12000	6061-T6 Bar 1.0" x 12.0"
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Comment: Qty.: 1.9031 f(s)/Unit Total : 9.5156 f(s)

6061-T6 Bar 1.0" x 12.0"

Material: 6061-T6 (QQ-A-200/8) 1.00" thick

Note: 2 per blank.

Batch *106701*

DSP 08/01/07

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blank: 21.75" x 12.00"

DSP 08/01/07

(3)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per folio D2523

RG 08/09/17 H.A 08/09/18 (6)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

H.A 08/09/18 RG 08/09/17 (6)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

RG 08/09/19 (6)

6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

Drill holes as per dwg D2523 using DT8560

FF 08/09/24 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:48 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING BRACKET

Job Number: 33047

Part Number: D2523

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

508/09/24 (x6)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M-L 08/09/26

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 108523

M-L 08/09/26

(6X)

(6X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/26

50

(6X)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: RT7

8/9/26

54

(6X)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MF 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33047
Description: Mounting Bracket		Part Number:	D2523
Inspection Dwg: D2523 Rev: A2		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005/-0.000	1.257				
1.076	+/-0.010	1.076				
1.985	+/-0.010	1.985				
Ø0.257	+0.005/-0.001	1.258				
9.372	+/-0.010	9.372				
1.035	+/-0.010	1.035				
Ø0.191	+0.005/-0.000	1.192				
7.546	+/-0.010	7.546				
2.776	+/-0.010	2.776				
2.776	+/-0.010	2.776				
0.875	+/-0.010	0.875				
R0.125	+/-0.010	0.125				
1.00	+/-0.030	1.00				
R0.125	+/-0.010	R.125				
0.750	+/-0.010	1.750				
0.250	+/-0.010	0.250				
R0.250	+/-0.010	R.250				
0.125	+/-0.010	0.131				
R0.125	+/-0.010	R.125				
R0.063	+/-0.010	R.063				

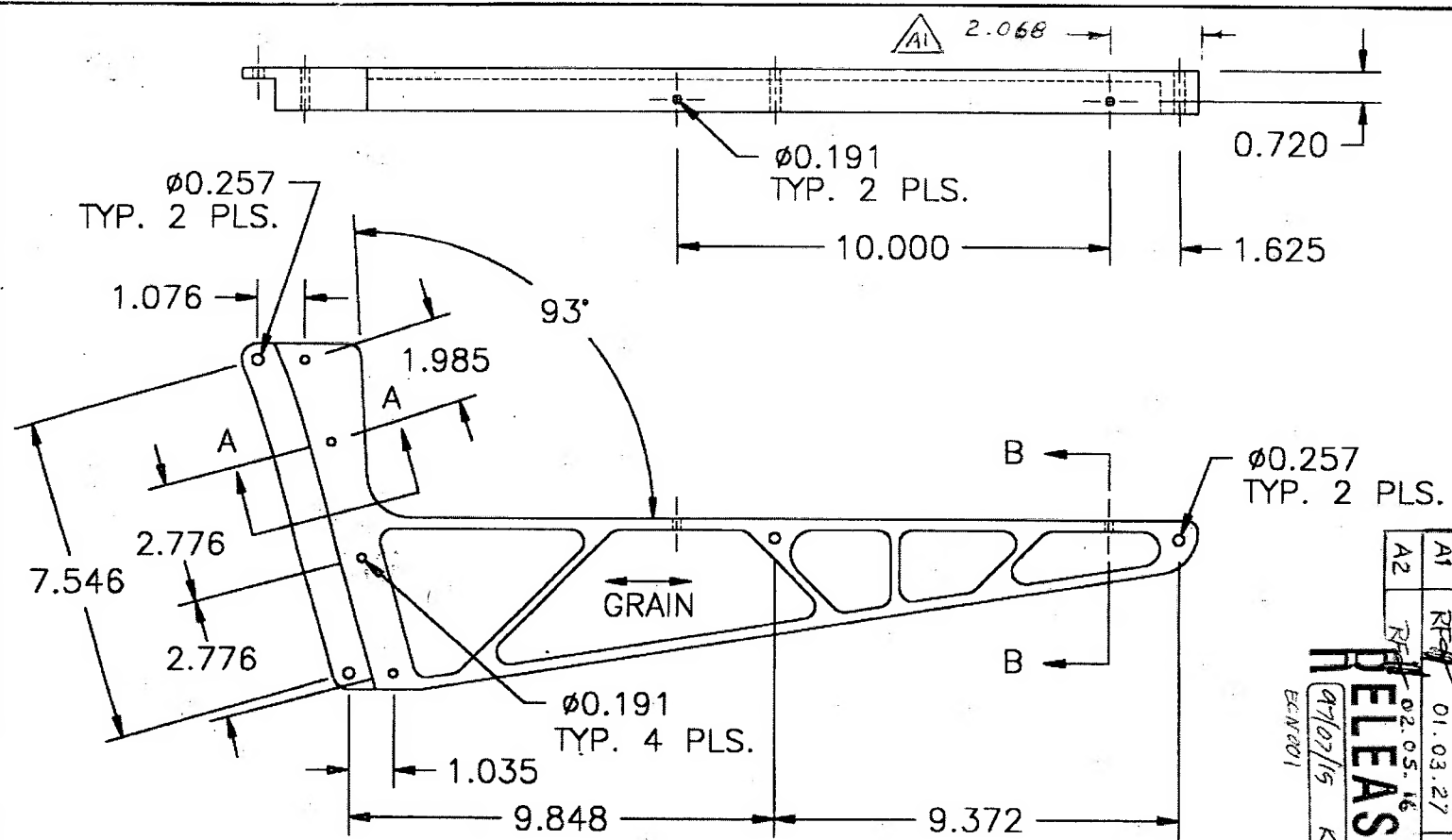
Measured by: <i>129</i>	Audited by: <i>9m</i>	Prototype Approval:	N/A
Date: <i>08/09/17</i>	Date: <i>08/09/19</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	<i>[Signature]</i>



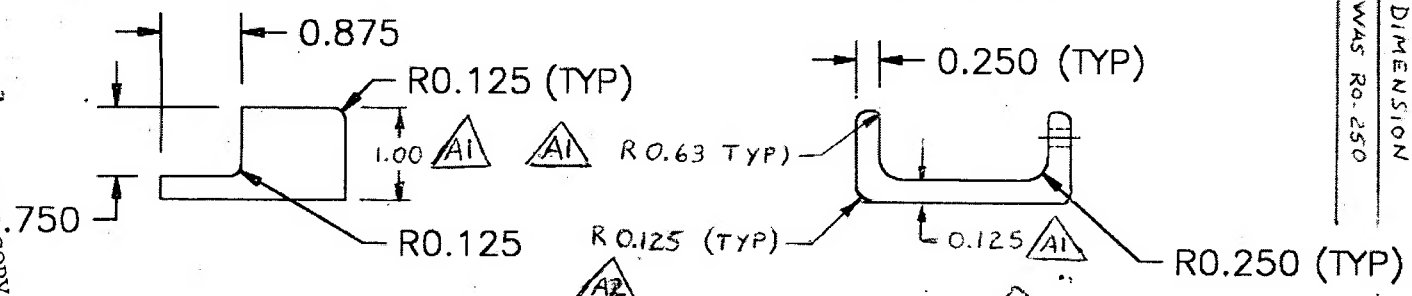
DESIGN		DRAWN BY		DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		REV. A
B2		KE				
CHECKED	APPROVED	DRAWING NO.				SHEET 1 OF 1
KE	KE	D2523				SCALE
DATE		TITLE				
95.12.20		MOUNTING BRACKET				1:4
A	95.12.20	NEW ISSUE				
A1	01.03.27	ADDED DIMENSION				
A2	02.05.16	R0.125 WAS R0.250				

RELEASED
07/07/15 KE
ECN201



SECTION A-A
SCALE 1:2

SECTION B-B
SCALE 1:2



MATERIAL: 6061-T6 QQ-A-200/8 1.00 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE PER DART QSI 005 4.3

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SHOOCOPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO
WITHOUT NOTICE

WORK ORDER
NO. 33047

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